



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1612
Job Sheet 169472



Part No: 647.1612

Job Qty: 12 ea ✓

Part Name: Splice Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/12/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A SHEET 5 IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.03 now prime at
ATG DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		1/4/18	0.00	0.00	Start Up Waterjet		SC 17/12/20
110	Waterjet	12 pcs		1/5/18	0.00	1.01	Waterjet1		SC 17/12/20
120	QC	12 pcs		1/5/18	0.00	0.00	QC2 Waterjet-1		SC 17/12/20
130	QC	12 pcs		1/5/18	0.00	0.00	QC8-1		38
140	Outsource	12 pcs		1/5/18	0.00	0.00	Outsource4		38
150	Packaging	12 pcs		1/5/18	0.00	0.00	Packaging2		DAS 38
160	QC	12 pcs		1/5/18	0.00	0.00	QC5		38
190	Packaging	12 pcs		1/5/18	0.00	0.00	Packaging3-1 CCK107		AG 38 18/01/2018
200	QC21-SA	12 Ea		1/5/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg, SEE NOTE #3 2- PRIME AS PER DWG, SEE NOTE #3

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.090 W123287	0	42	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Splice Plate	0.170inches + 0.005 - 0.001	0.175 0.169	Diameter	
2	Splice Plate	0.340inches ± 0.030	0.370 0.310		
3	Splice Plate	0.560inches ± 0.030	0.590 0.530		
4	Splice Plate	0.350inches ± 0.010	0.360 0.340		
5	Splice Plate	0.713inches ± 0.010	0.723 0.703		
6	Splice Plate	1.060inches ± 0.030	1.090 1.030		
7	Splice Plate	1.800inches ± 0.030	1.830		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

Job No: 169472
Mfg Date: 12/20/17

Start up Operation

647.1612

Change No:

Operation:

Revision:

PART NO:

Splice Plate



S025830



Completed By

Supervisor
Approval Verification

Coordinator
Approval

Incorrect Dimensions
Under tolerance
Incorrect
Part Missing

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Fc ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐

Out of Sequence ☐
Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

			1.770
8	Splice Plate	1.445inches $\pm$ 0.010	1.455 1.435
9	Splice Plate	2.320inches $\pm$ 0.030	2.350 2.290
10	Splice Plate	0.381inches $\pm$ 0.010	0.391 0.371
11	Splice Plate	0.606inches $\pm$ 0.010	0.616 0.596
12	Splice Plate	0.941inches $\pm$ 0.010	0.951 0.931
13	Splice Plate	2.030inches $\pm$ 0.030	2.060 2.000

Plex 12/12/17 1:45 PM dart.poulin.mario

DART
AEROSPACE
S025830

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1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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Splice Plate

PART NO: 647.1612

Original Serial #: S025830

Revision:

Operation: Outsource

Change No:

Mfg Date: 12/20/17

Job No: 169472

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914461

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ph: 613 632-9577		Fax: 613 632-1053	
		Ship Via			
		OUR TRUCK			
Quantity	Description				
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.				
20 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22303 PO: PO038727 Line: 13 Rev: A				
40 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22304 PO: PO038727 Line: 14 Rev: A				
8 ea	Part: 646.3312 Center Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22307 PO: PO038727 Line: 17 Rev: N/C				
15 ea	Part: 647.0116 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22295 PO: PO038727 Line: 5 Rev: A				
12 ea	Part: 647.1612 Splice Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22295 PO: PO038727 Line: 5 Rev: A				
Made in Canada.					
Page 1 of 2					

Made in Canada



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER PO038727

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038727
PO Date: 1/5/18
Due Date: 1/12/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

JAN 11 2017

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169405	647.1513	Upper Deflector Issue P/O to ATG : Hard Anodize Color Black / Prime as per Dwg 647.1500 Rev. D	Firmed	1/11/18	12 pcs	0 pcs	12 pcs	\$12.45/pcs	\$149.40
Line Item Note #1 Priority - RUSH!!!										
2	168276	647.0114	Clip Issue P/O ATG, black anodize and prime as per dwg 647.0114 Rev. A	Firmed	1/30/17	50 pcs	0 pcs	50 pcs	\$10.20/pcs	\$510.00
3	168277	647.0115	Clip Issue P/O to ATG : 1- Hard Anodize Color Black And Prime as per Dwg 647.0100 Rev.A	Firmed	1/30/17	50 pcs	0 pcs	50 pcs	\$10.20/pcs	\$510.00
4	168273	647.0111	Panel Issue P/O to ATG : Hard Anodize, Color Black / Prime as per Dwg 647.0100 Rev. A	Firmed	1/30/17	15 pcs	0 pcs	15 pcs	\$39.95/pcs	\$599.25
5	168278	647.0116	Doubler Issue P/O ATG, black anodize and prime as per dwg 647.0116 Rev. A	Firmed	1/30/17	15 pcs	0 pcs	15 pcs	\$8.10/pcs	\$121.50
6	168286	647.1511	Lower Deflector Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 647.1500 Rev. D.	Firmed	1/30/17	4 pcs	0 pcs	4 pcs	\$11.85/pcs	\$47.40
7	169472	647.1612		Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$7.60/pcs	\$91.20